










Date: Monday, 16/03/2009 2:00:50 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: COMFORT SEAT- FRAME
<b>Job Number</b>	: 46514	<b>Part Number</b>	: D37521
<b>Estimate Number</b>	: 13369	<b>Drawing Number</b>	: D3752-1 UNDER REVIEW <i>MP 09/03/25</i>
<b>P.O. Number</b>	:	<b>Project Number</b>	: N/A
<b>This Issue</b>	: 16/03/2009 <b>S.O. No.</b> :	<b>Drawing Revision</b>	: C UNDER REVIEW <i>MP 09/03/25</i>
<b>Prsht Rev.</b>	: NC	<b>Material</b>	:
<b>First Issue</b>	: // <b>Type</b> : THERMOFORMING	<b>Due Date</b>	: 25/03/2009 <b>Qty:</b> 5 <b>Um:</b> Each
<b>Previous Run</b>	: 43360		
<b>Written By</b>	:		
<b>Checked &amp; Approved By</b>	: <u>JUD 09.03.16</u>		
<b>Comment</b>	: Est. REV: A New Issue 08.06.03 DL verified by:DD Est Rev. B Dwg. Update 08/07/22 DL Est. Rev. C Dwg. Update Shorter length 08/10/28 DL		
<b>Additional Product</b>			
Job Number: 			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
			
<b>Comment:</b> HAND FINISHING THERMOFORMING			
Set up machine program D3752-1 Set up clamping frame as per folio <i>M109455 BB 09/03/30 x6</i>			
2.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET	
			
<b>Comment:</b> Qty.: 10.6670 sf(s)/Unit Total : 53.3350 sf(s) GE PLASTICS LEXAN SHEET			
Batch # <i>M109455 BB 09/03/20 x6</i>			
3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
			
<b>Comment:</b> HAND FINISHING THERMOFORMING			
1) Cut Blanks <i>BB 09/03/20 x6</i>			
4.0	THERMOFORMING	THERMOFORMING MACHINE	
			
<b>Comment:</b> THERMOFORMING MACHINE			
Thermoform as per Dwg. D3752 and Folio			
Dwg. Rev. <u>C</u> Folio Rev. <u>BB 09/03/20 x6</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 16/03/2009 2:00:50 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COMFORT SEAT- FRAME

Job Number: 46514

Part Number: D37521

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BB 09/03/23 (x6)

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/03/23 (x6)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT TRIMMED PARTS

1) Check dimensions to ensure conformity to drawing tolerances.

BB 09/03/23 (x6)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/03/04 (x6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

2 STUNK  
P/P 46514 09/03/24 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/25

Job Completion



mf  
09-03-24

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/04/15

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/3/24	#6-0	Found a mark that goes across the top (about 7.50" from top) around <del>3/4</del> about 3/4 of the part. D.C. mark was on mat.	MP 09/03/24	NO ENGINEERING ACTION REQ'D	MP 09/03/24	S 09/03/24	MP 09/03/24	S 09/03/24
		and camethrough while thermoforming.						

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	46514
Description: Seat Frame		Part Number:	D3752-1
Inspection Dwg: D3752	Rev: C	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

Measured by:		Date:	
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### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	.067	✓			
0.035	Min	.047	✓			
0.040	Min	.069	✓			
0.075	Min	.110	✓			
0.052	Min	.111	✓			
0.021	Min	.035	✓			
0.036	Min	.063	✓			

Measured by:	BB	Date:	09/03/23
Audited by:	S	Date:	09/03/24
Prototype Approval:	n/a	Date:	1/1

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	

DART AEROSPACE LTD		Work Order:	46514
Description: Seat Frame		Part Number:	D3752-1
Inspection Dwg: D3752	Rev: C	Page 1 of 1	

#5

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

## THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

Measured by: BBDate: 09/03/23

## TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	.059	✓			
0.035	Min	.047	✓			
0.040	Min	.054	✓			
0.075	Min	.106	✓			
0.052	Min	.109	✓			
0.021	Min	.036	✓			
0.036	Min	.047	✓			

Measured by: BBDate: 09/03/23Audited by: 8Date: 09/03/24Prototype Approval: n/aDate: n/a

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	<u>[Signature]</u>

DART AEROSPACE LTD		Work Order: 46514
Description: Seat Frame		Part Number: D3752-1
Inspection Dwg: D3752	Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

Measured by:		Date:	
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#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	.064	✓			
0.035	Min	.050	✓			
0.040	Min	.065	✓			
0.075	Min	.115	✓			
0.052	Min	.110 <del>.104</del>	✓			
0.021	Min	.032	✓			
0.036	Min	.047	✓			

Measured by: BB	Date: 09/03/23
Audited by: S	Date: 02/03/24
Prototype Approval: n/a	Date: n/a

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	

DART AEROSPACE LTD		Work Order:	46514
Description: Seat Frame		Part Number:	D3752-1 7
Inspection Dwg: D3752 Rev: C		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

Measured by:	BB	Date:	07/03/23
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#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0 0.028	Min	.052	✓			
0 0.035	Min	.050	✓			
0.040	Min	.072	✓			
0 0.075	Min	.111	✓			
0.052	Min	.104	✓			
0.021	Min	.040	✓			
0.036	Min	.075	✓			

Measured by:	BB	Date:	07/03/24
Audited by:	S	Date:	07/03/24
Prototype Approval:	n/a	Date:	1/19

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	



DART AEROSPACE LTD		Work Order:	46514
Description: Seat Frame		Part Number:	D3752-1
Inspection Dwg: D3752	Rev: C	Page 1 of 1	

#2

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

## THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

Measured by: BB

Date: 09/03/23

## TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	.052	✓			
0.035	Min	.048	✓			
0.040	Min	.062	✓			
0.075	Min	.104	✓			
0.052	Min	.101	✓			
0.021	Min	.036	✓			
0.036	Min	.054	✓			

Measured by: BB

Date: 09/03/23

Audited by: S

Date: 09/03/21

Prototype Approval: n/a

Date: n/a

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	

DART AEROSPACE LTD		Work Order:	46514
Description: Seat Frame		Part Number:	D3752-1 <del>12</del> * 1
Inspection Dwg: D3752	Rev: C	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

Measured by: BB	Date: 09/03/23
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### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	.065	✓			
0.035	Min	.057	✓			
0.040	Min	.072	✓			
0.075	Min	.106	✓			
0.052	Min	.105	✓			
0.021	Min	.035	✓			
0.036	Min	.062	✓			

Measured by: BB	Date: 09/03/23
Audited by: 8	Date: 09/03/24
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	✓

